

Work Order ID 50972

July 28, 2009 1:37:17 PM



Page 1

Item ID: D3940-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Floor Protector (407)

Start Date: 07/28/2009 Start Qty: 3.00



Cust Item ID:

Required Date: 07/31/2009 Req'd Qty: 3.00

Customer:

Reference:

Run Start



Approvals: Process Plan: MF Date: 09-07-28 Fooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

BB 09/07/29 (X3) (X4) BB 09/09/11 BB

M111588 26X51

M111588 26X51 (X4)

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA042 using tool DT9502
Dwg Rev: A
Folio Rev: A

BB 09/07/29 (X3) (X4) BB 09/09/11 BB

X1 SCRAP P10



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3940-1 PAR #: _____ Fault Category: Thermoforming NCR: Yes No DQA: / Date: 05-05-16
 Resolution: Scrap Disposition: Scrap. QA: N/C Closed: / Date: 05-09-16

NCR: <u>50972</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
(A) 09/07/11	110	PART BURNED x1 Machine Malfunction HEATER STUCK OVER Machine malfunction	<u>/</u>	RESET MACHINE - replace qty 1 - destroy	<u>BB</u> 09/07/25	<u>S</u> 09/09/11	<u>/</u>	<u>/</u>
(B) 05-08-11	110	3 parts scrap. Min mat'l thickness is too thin. Re. to / Turns out 2 circuits were blown.	<u>/</u>	destroy into replace. - review Polio for to produce good parts. CREATED "HEATRIES. FOLIO" TO INSURE ALL HEATERS ARE FUNCTIONING	<u>BB</u> 09/14/09	<u>↓</u>	<u>/</u>	<u>/</u>

NOTE: Date & initial all entries

Work Order ID 50972

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Customer:

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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Visually inspect part for proper formation and texture

BB 09/08/04

X3

BB 09/09/11 X4

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

27 8/2/09/11

X4

140



HandThermo

Hand Finishing Thermoforming

Memo

0.00

0.00

1-Trim to finished dimensions as per Dwg

BB 09/08/05

X3

BB 09/09/11 X4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Setup Start



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Stop



Item Name: Floor Protector (407)

Start Date: 07/28/2009 Start Qty: 3.00



Cust Item ID:

Required Date: 07/31/2009 Req'd Qty: 3.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Complete FAI document

38 09/09/11 X4

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

22509/11

24 6

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

7/9/11 4 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Revision ID: A

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Start Date: 07/28/2009 Start Qty: 3.00

Required Date: 07/31/2009 Req'd Qty: 3.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/09/16

BF 09-9-15 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 50972



Parent Item: D3940-1RevA



Parent Item Name: Floor Protector (407)

Start Date: 07/28/2009

Required Date: 07/31/2009

Comments:

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	600.0000	27.0900			



Lexan Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

111588

600

600

1

BB 07/28/09
(X4)
BB 07/29/09
(X4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	50972
Description: FLOOR PROTECTOR 457		Part Number:	D3940-1
Inspection Dwg:	Rev:	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 09/08/04

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4/58	REF	45.625				
20.8	REF	20.825	✓			
.50	Min	.55	✓			
.62	Min	.65	✓			
.38	Min	.39	✓			
.080	Min	.085	✓			
.050	Min	.055	✓			

Measured by: BB

Date: 09/08/04

Audited by: S

Date: 09/08/11

Prototype Approval: _____

Date: _____

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

DART AEROSPACE LTD	Work Order: 50872
Description: FLOOR PROTECTOR (402)	Part Number: D 3940-1
Inspection Dwg: D3940 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 09/10/09

09/09/10 BB

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
45.8	REF	45.8	✓			
20.8	REF	20.9	✓			
.50	Min	.55	✓			
.62	Min	.63	✓			
.38	Min	.4	✓			
.080	Min	.085	✓			
.050	Min	.073				

Measured by: BB

Date: 09/21/09

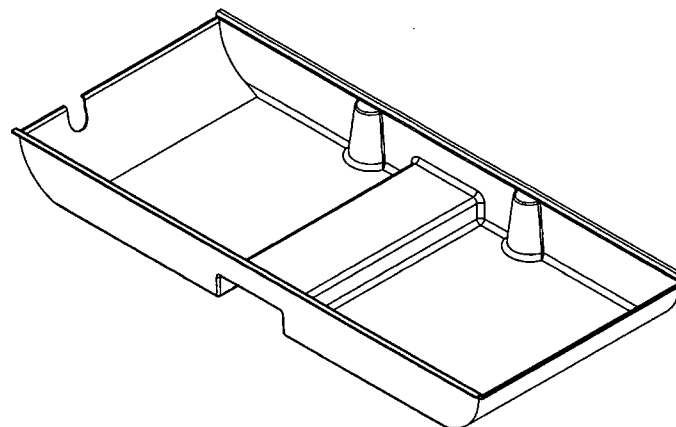
Audited by: D

Date: 07/07/10

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



50972

D3940-1 FLOOR PROTECTOR (407)

RELEASED
09/04/01

NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS. 118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3940-1" USING VIBRATING STYLUS
- 7) WEIGHT: 4.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9502 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" EXCEPT AS SHOWN

A	NEW ISSUE	PH	09.04.01
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SE	DRAWING NO. D3940	REV. A
MFG. APPR.	SE	SHEET 1 OF 2	
APPROVED	SE	TITLE	SCALE
DE APPR.	SE	FLOOR PROTECTOR (407)	NTS
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

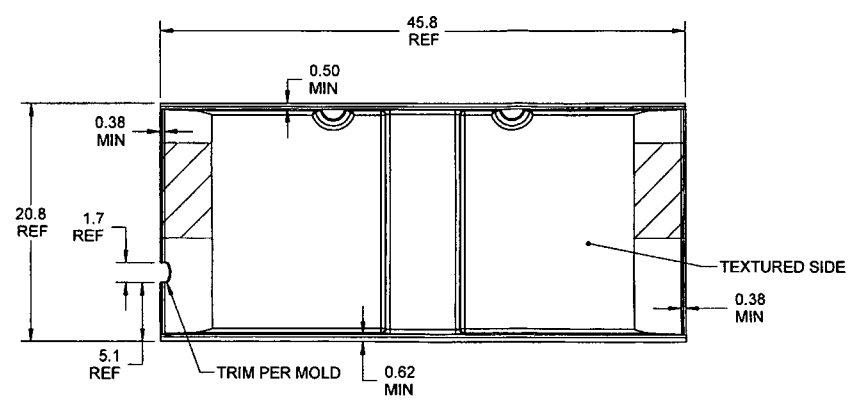
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

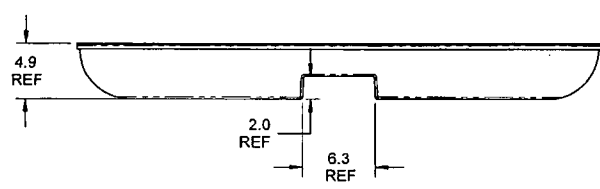
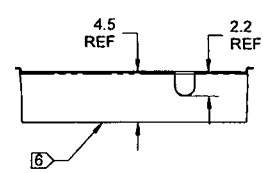
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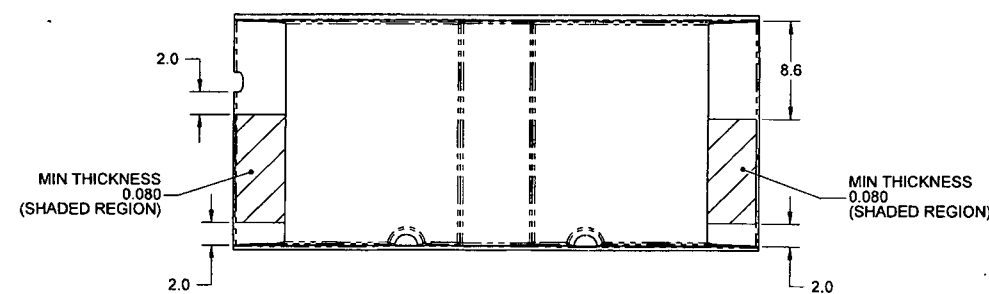
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A

A

D3940-1 FLOOR PROTECTOR (407)

#50972

RELEASED

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3940	REV. A
MFG. APPR.		SHEET 2 OF 2	
APPROVED		TITLE FLOOR PROTECTOR (407)	SCALE NTS
DE APPR.		COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

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